

Work Order ID 53057

October 22, 2009 1:58:25 PM



Page 1

Item ID: V D130-780-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: SPACEPOD LH

Start Date: 21/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *RF*

Date: *09-10-22*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN-D130-780

B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels per PPP D130-780-041 CHG 003

*S 10/06/28
12/06/01*

for BG 10/05/26

PTO

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

RT 10-05-20

120

0.00



Small Fab

Memo

0.00

Small Fab



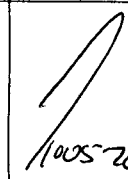
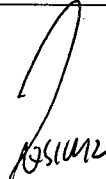

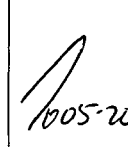
-Assemble as per dwg D3188,
-use door to transfer drill hole location.
-Install inserts

RT 10-05-25

PTO

W/O: 53057		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-05-20 10-05-20	120 120	Drill + remove foam core as per drawing 3188 section I-I. Fill w/ Hysol 934 + milled Fibres Hysol 934 B 113022 milled Fibres B 100859	ET	10-05-20			S 10/05/20

Part No: D130-780-044 PAR #: _____ Fault Category: Small FAS NCR: Yes No DQA: _____ Date: 10/05/20
 Resolution: rework Disposition: rework QA: N/C Closed Date: 10/06/20

NCR: 53057		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10-05-20	120	while installing striker plate on pad one rivet MS20426AD4-5 squished improperly. Upon drilling out rivet to replace the rivet spun causing hole in striker plate		Fill affected hole w/ hysol 934 + milled fibres + re-drill + install new rivets x 2 MS20426AD4-5 + striker plate D2237 Hysol 934 B 113022 milled fibre B 100859	ET 10-05-20	S 10/05/20		
	RC	+ spacer pad to enlarge back of attr		rivet MS20426AD4-5 x 2 B 6733 striker plate D2237 B 57255				

NOTE: Date & initial all entries

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Item ID: D130-780-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: SPACEPOD LH

Start Date: 21/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

References:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	S 10/05/05			(X)			
140 HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch 114832 Memo TOP SURFACE OF POD	0.00 0.00				FX	10-05-25		
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				①	BR 10-5-25		

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Item ID: D130-780-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: SPACEPOD LH

Start Date: 21/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-5-21

SP

PRT-7
PTO ->

170

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

S 10/05/28
1060601

(40)

180

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D130-780-041

Location:

PPP Rev:

10-5-31 SP

Dart Aerospace Ltd

W/O: 53057		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/05/28	#100	Perm. Issued. Parts missing From Pick List. ADD Parts to w/o - D3815 B 33523 Qty x 3 - MS266E37214 Qty x 8	SP	10-5-28			S	
	S	- MS24694254 m 113359 Qty x 6 S - A3235-020- ⁹³⁵ m 106150 Qty x 8	SP				10/05/28	
10/05/28	#100	ADD update qty's of MS210423 to 22 + NAS1149D03635 to 14 update w/o + Bom. ADD copy of updated Bom.	SP	10.06.02			8/10/28	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53057

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Item ID: D130-780-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: SPACEPOD LH

Start Date: 21/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/02

MF
10-6-02

Picklist Print

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Page 1

Work Order ID: 53057

Parent Item: D130-780-041RevA

Parent Item Name: SPACEPOD LH

Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN526-832R24 Purchased No



Screw AN526C832R24

110 110179 x4

201.0000 4.0000



IT 10-05-20

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

201

16895

201

D3538-1RevA

Manufactured No



Hinge Bracket

110

Each

24.0000

2.0000



IT 10-05-20

B55012 x2

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

14

48197

14

Main Warehouse

ST111

10

50336

10

MS20426AD4-5

Purchased

No



Rivet

110

Each

7,910.000

4.0000



IT 10-05-20

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7910

4067

1097

6733

1831

6874

4982

x4

Dart Aerospace Ltd

W/O: 53057		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-05-25	110	add to kit permanent change # 02179 ^{f2} 3 35432	<i>[Signature]</i>	10-05-25 10.05.02			<i>[Signature]</i> 10/5/02

Part No: D130-780-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53057

Parent Item: D130-780-041RevA

Parent Item Name: SPACEPOD LH


Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L08  Nut		Purchased	No			110	Each	407.0000	4.0000			

W 114330 x4

ST 10-05-25

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	407	
110002	24	
111889	51	
112243	47	
112492	85	
112612	100	
112794	100	

NAS1149DN832J

Purchased

No

110

Each

375.0000

4.0000



WASHER

W 114740 x4

ST 10-05-25

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	375	
111193	3	
111359	72	
112385	300	

Picklist Print

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Work Order ID: 53057

Parent Item: D130-780-041RevA

Parent Item Name: SPACEPOD LH


Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN526C832R14		Purchased	No			150	Each	937.0000	8.0000			
												
Screw												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

937

104916

937

160

Each

73.0000

2.0000

AN3-10A

Purchased

No



Bolt

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

73

111119

73

160

Each

161.0000

4.0000

AN3-3A

Purchased

No



Bolt

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

161

111925

11

112314

50

112720

100

Picklist Print

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Work Order ID: 53057

Parent Item: D130-780-041RevA

Parent Item Name: SPACEPOD LH

Comments:


Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN3-6A  Bolt		Purchased	No			160	Each	135.0000	4.0000			
---	--	-----------	----	--	--	-----	------	----------	--------	--	--	--

Warehouse Loc Qty Loc Code

Location


Main Warehouse

ST 135

112082 7

112513 28

112720 100

AN525-10R7  Screw		Purchased	No			160	Each	131.0000	38.0000			
--	--	-----------	----	--	--	-----	------	----------	---------	--	--	--

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 131

106166 30

110844 15

112314 10

112411 76

M113359 10-5-2781

18 25
M113288 M113359
10-5-2781

Picklist Print

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Work Order ID: 53057

Parent Item: D130-780-041RevA

Parent Item Name: SPACEPOD LH

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN5-5A Bolt		Purchased	No			160	Each	107.0000	1.0000		10-5-27	SL

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	107	
103585	3	
110363	4	
110865	100	

D3015-3RevB

Manufactured No

Locknut

160 Each 328.0000 1.0000

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	128	
43758	26	
44446	49	
48238	53	
Main Warehouse		
ST59	200	
51711	200	

Picklist Print

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Work Order ID: 53057

Parent Item: D130-780-041RevA

Parent Item Name: SPACEPOD LH


Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3550-1RevB  Strut		Manufactured	No			160	Each	17.0000	1.0000			

10-5-27SP

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	17	
48367	17	

D3554-7RevA



Ball Stud

Manufactured No

160 Each 60.0000 1.0000

10-5-27SP

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	60	
37674	60	

D3798-041RevA



Spacepod Floor

Manufactured No

160 Each 1.0000 1.0000

B53490 10-5-27SP

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	1	
45578	1	

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Shop Packet Print

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Picklist Print

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Work Order ID: 53057

Parent Item: D130-780-041RevA

Parent Item Name: SPACEPOD LH


Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009


Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3815-041RevA		Manufactured	No			160	Each	7.0000	2.0000			
												
Web Assembly												


Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	7	
45729	1	
46356	6	

10-5-27 SP

D3837-1RevB		Manufactured	No			160	Each	7.0000	1.0000			
												
Decal												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	7	
46231	7	

10-5-27 SP

D3837-3RevB		Manufactured	No			160	Each	8.0000	1.0000			
												
Decal												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	8	
46232	8	

10-5-27 SP

Picklist Print

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Work Order ID: 53057

Parent Item: D130-780-041RevA

Parent Item Name: SPACEPOD LH

Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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MS21042L3

Purchased

No

160

Each

3,430.000

16.0000

22

Nut

M113644 10-5-27 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3430

110844

32

111274

35

111668

863

112314

2000

112385

500

MS24694-S67

Purchased

No

160

Each

103.0000

7.0000

Screw

10-5-27 8

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

103

101662

13

106166

1

111965

89

7

Picklist Print

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Work Order ID: 53057

Parent Item: D130-780-041RevA

Parent Item Name: SPACEPOD LH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS24694-S69

Purchased

No

160

Each

118.0000

1.0000



Screw

10-5-27

38

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

118

103574

5

110153

13

112492

100

NAS1149D0332J

Purchased

No

160

Each

342.0000

16.0000



Washer

1113231

10-5-27

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

342

110625

16

110844

126

112794

200

NAS1149D0363J

Purchased

No

160

Each

2.0000

2.0000



Washer

1114292

10-5-27

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

112314

2

Picklist Print

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Work Order ID: 53057

Parent Item: D130-780-041RevA

Parent Item Name: SPACEPOD LH

Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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NAS1149D0563J Purchased No



Washer

160 Each 100.0000 3.0000



M113706 10-3-27SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

100

112794

100

D130-780-043RevA u Manufactured No



Spacepod Door Assembly, LH

D3188-1MRRevE j Manufactured No



SPACEPOD BODY LH

D3547-1RRevA u Manufactured No



Bracket

B 53065

B 53070

RT 10-05-18

RT 10-05-18

10-5-27SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

22

35455

8

50260

14

1

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Work Order ID: 53057

Parent Item: D130-780-041RevA

Parent Item Name: SPACEPOD LH


Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AKS4-1032-130		Purchased	No			110	Each	1.0000	28.0000			
												
Inserts	4654	1032-130										

✓
M 114654

ST 10-05-25

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

1

6087

1

D2237RevD1

Manufactured

No



Striker Plate

110

Each

81.0000

2.0000

B 57255 02

ST 10-05-20

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

5

46162

5

Main Warehouse

ST022

76

50348

21

52327

55

Picklist Print

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Work Order ID: 53057

Parent Item: D130-780-041RevA

Parent Item Name: SPACEPOD LH


Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
A3235-020-935		Purchased	No			160	Each	694.0000	8.0000			
												
Washer - Countersunk												

IT 10-05-25

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	694	
104156	3	
106150	691	

MS21042L5

Purchased

No

160

Each

1,077.000

1.0000

Nut

113523 10-5-27 SP

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	1077	
110382	10	
111127	4	
111636	63	
112314	1000	

AKS4-1032-130

Purchased

No

160

Each

1.0000

10.0000

Inserts

114707 10-5-27 SP

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	1	
6087	1	

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Shop Packet Print

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Picklist Print

Page 13

October 22, 2009 1:58:32 PM

Work Order ID: 53057

Parent Item: D130-780-041RevA

Parent Item Name: SPACEPOD LH

Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D130-780-013RevA		Manufactured	No			160	Each	2.0000	1.0000			
Switch Relocation												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FG	2	
50272	2	

D130-780-011

Aft LH Door Hinge Kit

Manufactured

No

CHG003

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FG010	1	
45530	1	

B33079 10-5-276

B36457 16-6-1

GENERAL NOTES:

1) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

1. MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

2) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S.
APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: D3188-1 = N/A
D3188-2 = N/A
D3188-3 = N/A
D3188-5 = N/A
D3188-6 = N/A
D3188-7 = N/A

8) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING

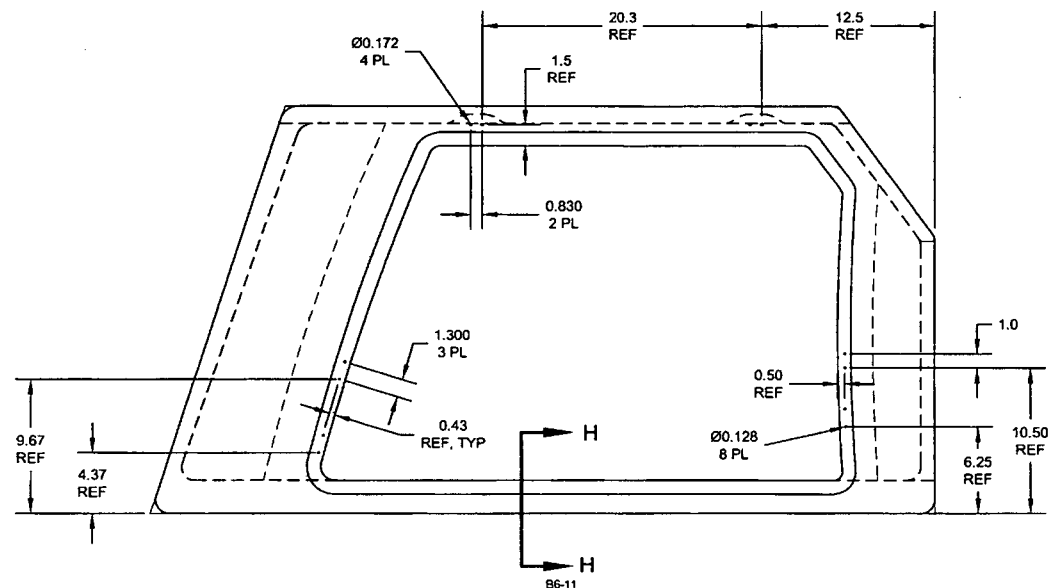
9) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO APPROVAL
WITHOUT
WORK ORDER
NO. 53057
2/09-10-22

RELEASED
2009-10-20
MD

F	REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS; ADD CHAMFER IN SECTIONS A-A (ZN C7-10) & H-H (ZN B7-11)	RF	09.07.13
E	ADD HYSOL/ FIBER OPTION ON SHEET 11	CB	07.04.02
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	CB	06.10.06
A	NEW ISSUE	CP	03.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	#	DRAWING NO.	REV. F
MFG. APPR.	W	D3188	SHEET 1 OF 11
APPROVED	#	TITLE	SCALE
DE APPR.	#	SPACEPOD BODY	NTS
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D3188-1 SPACEPOD BODY
MAKE FROM D3188-1M

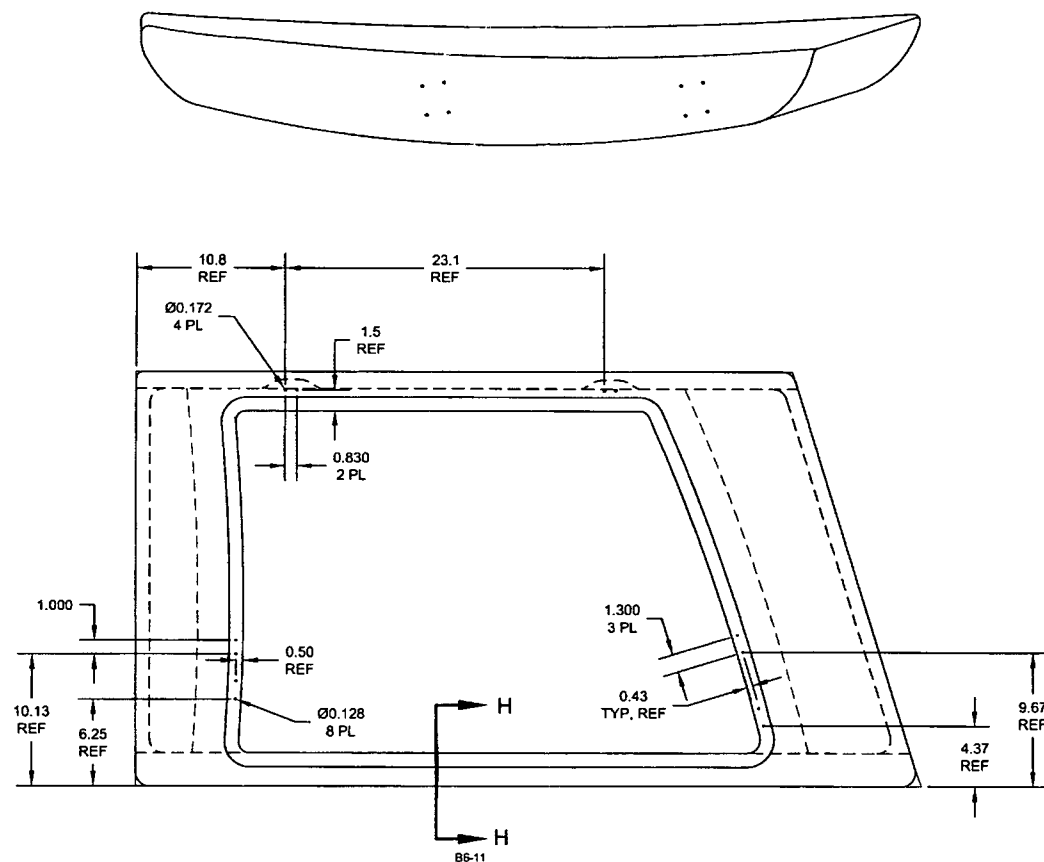
NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

RELEASED
2009-10-20
MD

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 2 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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D3188-2 SPACEPOD BODY
MAKE FROM D3188-2M

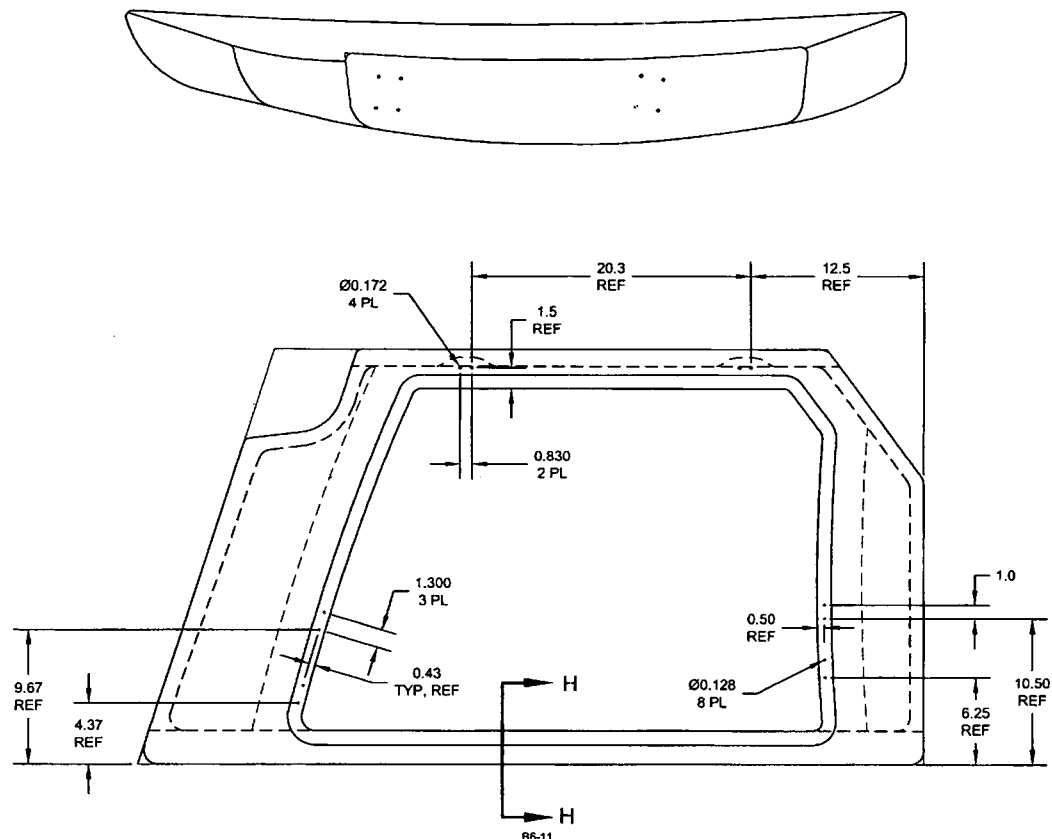
NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

RELEASED
2009-10-20
MP

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 3 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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D3188-3 SPACEPOD BODY
MAKE FROM D3188-3M

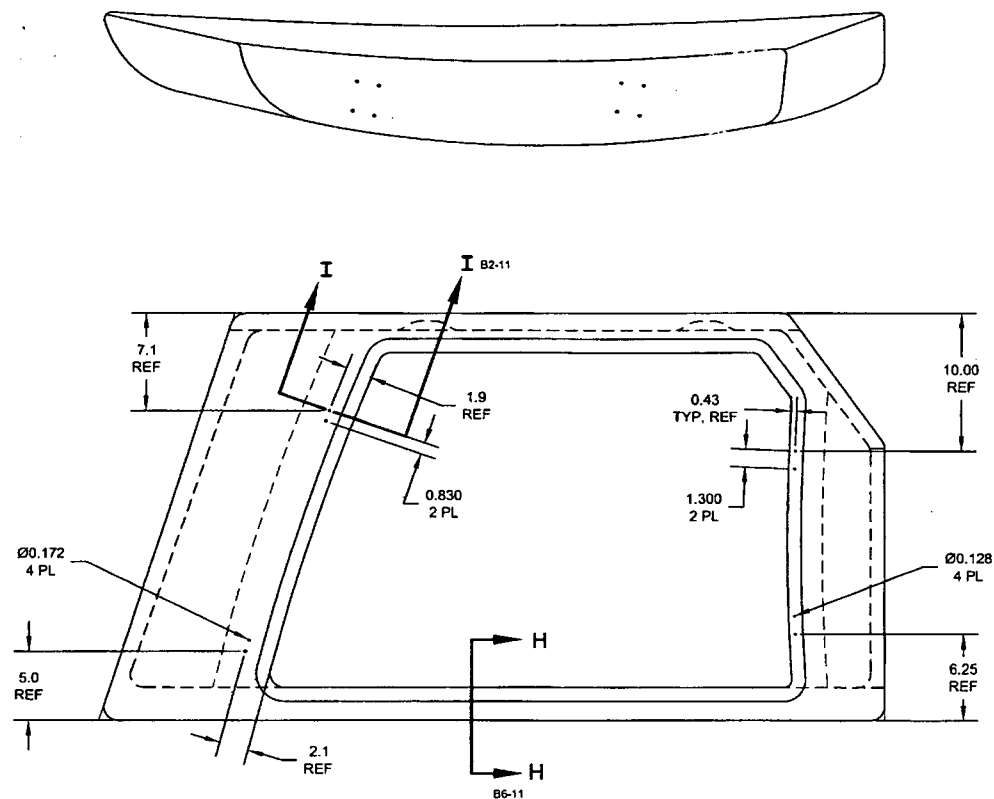
RELEASED
2009-10-20
MD

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 4 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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D3188-5 SPACEPOD BODY
MAKE FROM D3188-1M

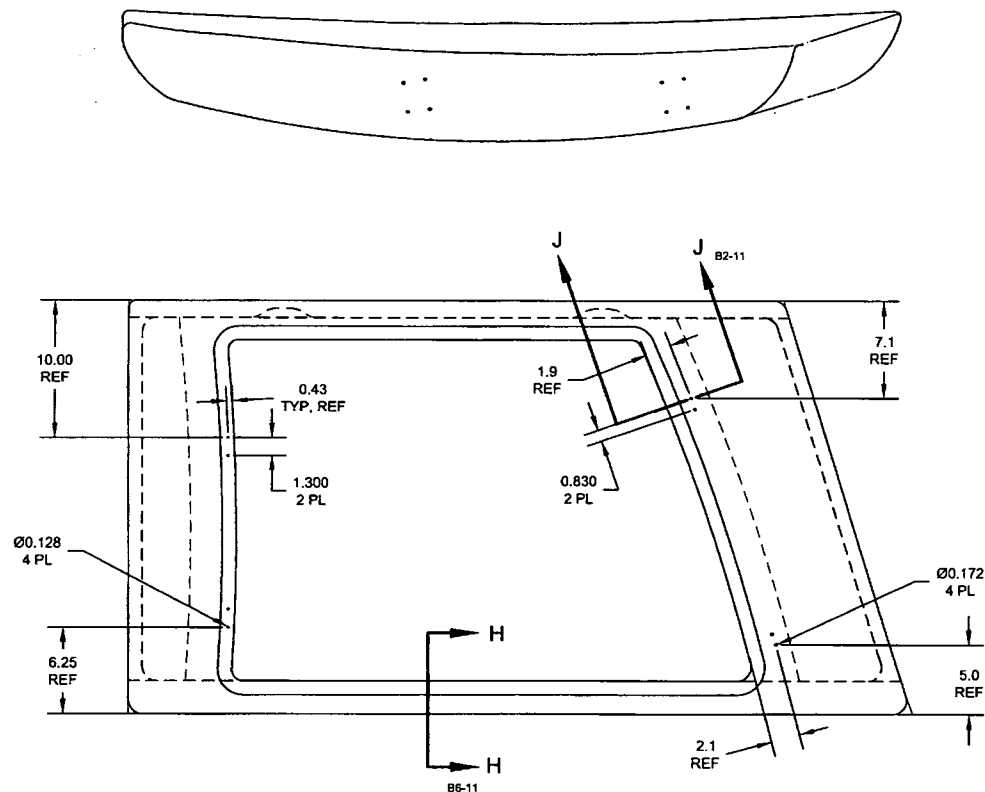
NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 5 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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D3188-6 SPACEPOD BODY
MAKE FROM D3188-2M

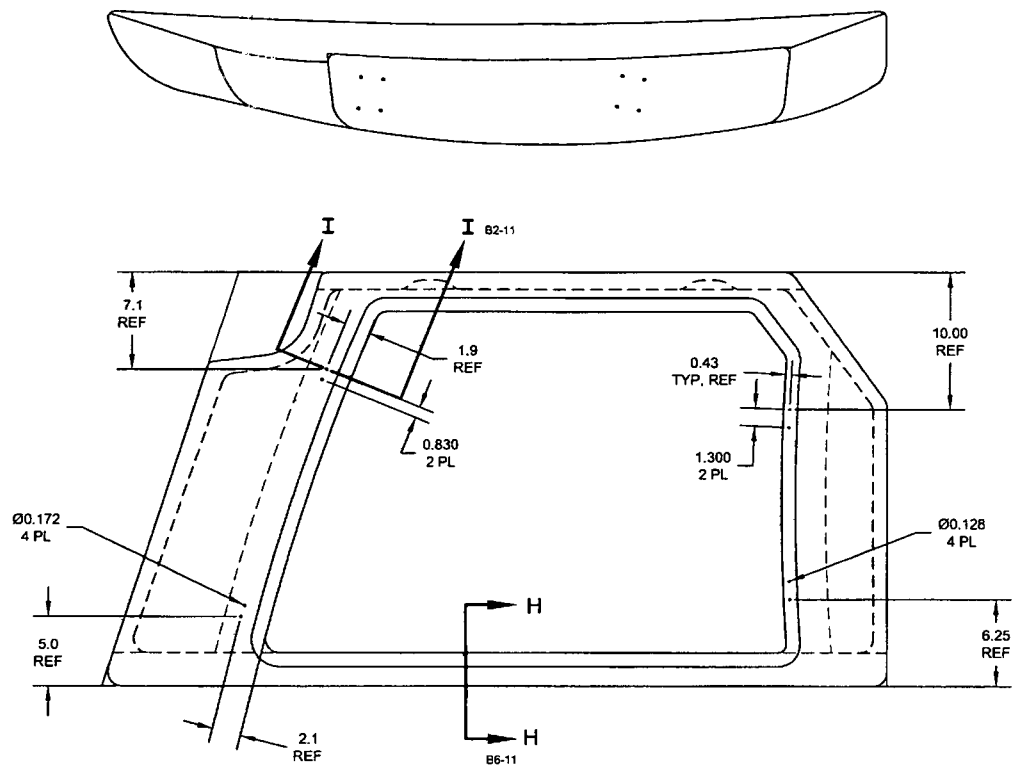
RELEASED
2009-10-20

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 6 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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D3188-7 SPACEPOD BODY
MAKE FROM D3188-3M

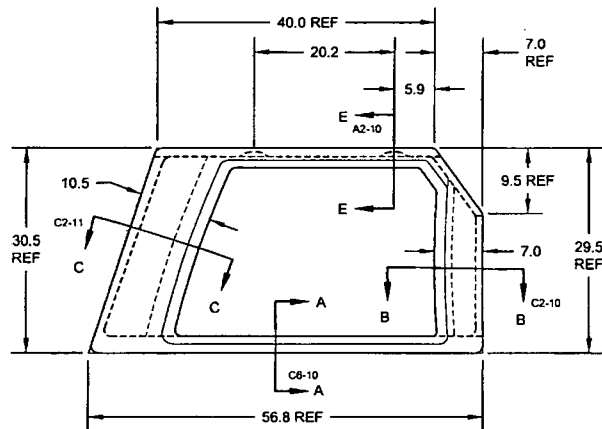
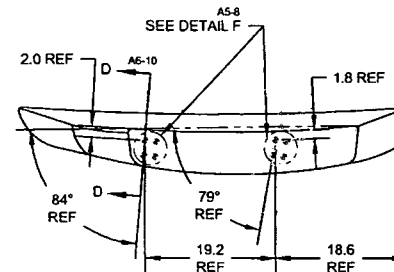
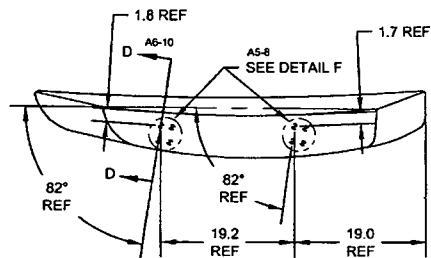
RELEASED
2009-10-20
AM

NOTE:

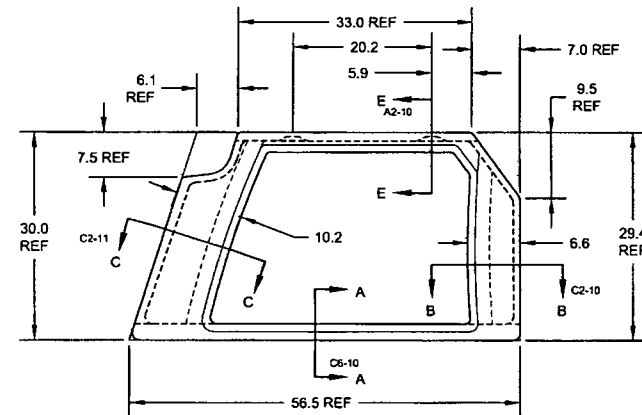
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 7 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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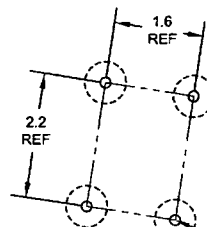
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D3188-1M SPACEPOD BODY



D3188-3M SPACEPOD BODY



DETAIL F

D3-8
D7-8

INSTALL
D2213 SPACER
8 PL
SEE SECTION D-D
A6-10

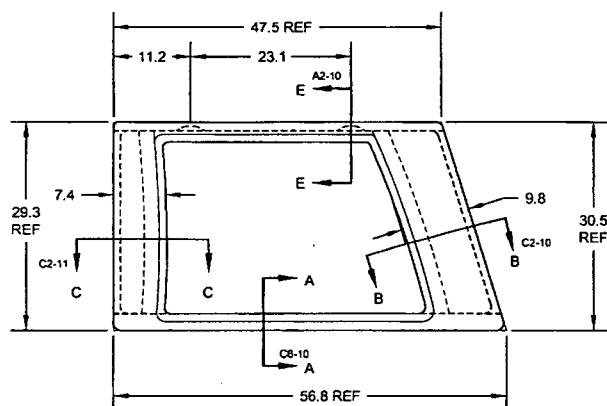
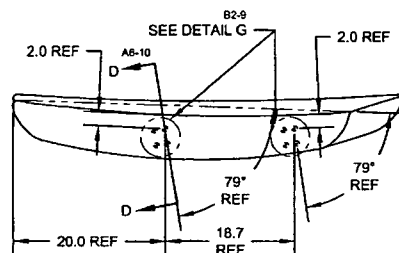
D3186-1M/-3M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

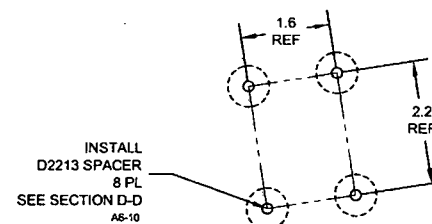
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2009-10-23

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3188	SHEET 8 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
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D3188-2M SPACEPOD BODY



DETAIL G D6-9

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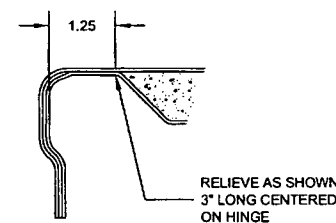
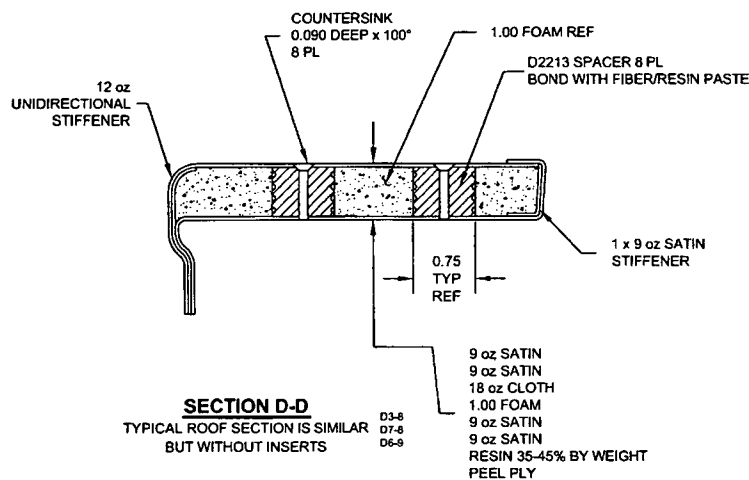
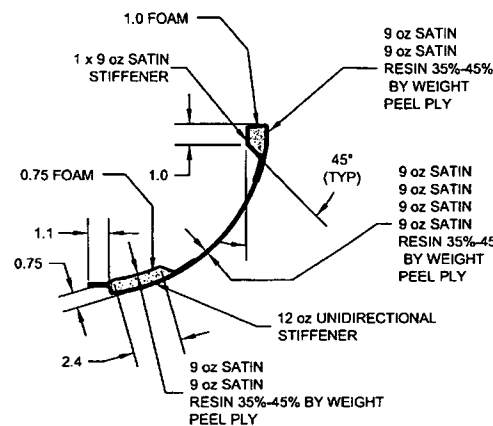
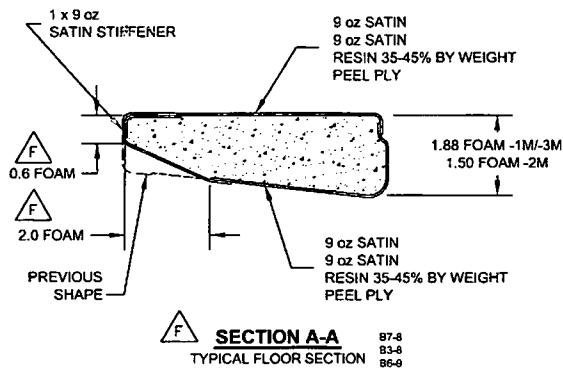
D3188-2M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3188	SHEET 9 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
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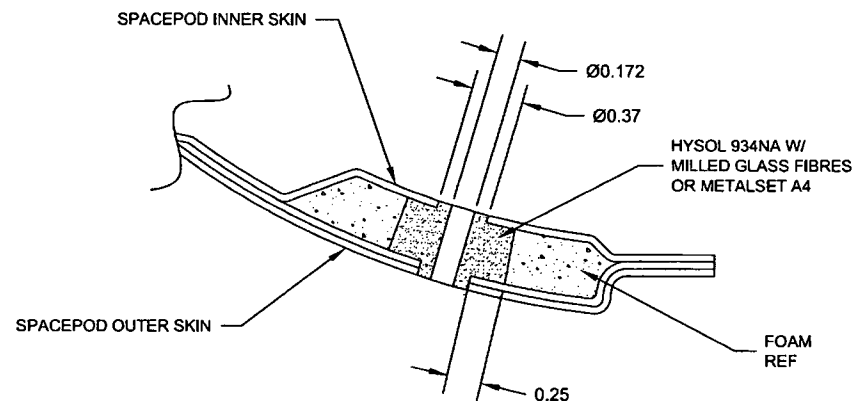
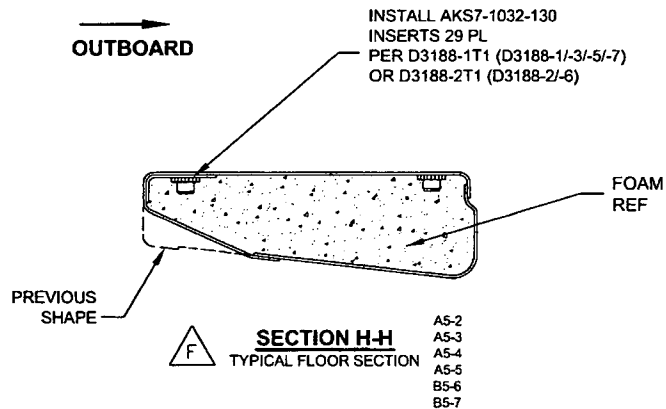
OUTBOARD



RELEASED
2009-10-27

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	RF	D3188	SHEET 10 OF 11
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	SPACEPOD BODY	NT
DATE	09.07.13	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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53057



SECTION I-I
SECTION J-J OPPOSITE
4 PLACES PER POD

C5-5
C4-6
C5-7

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2009-10-20

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 11 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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5.0 PARTS LIST

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
X							D130-780-041	SPACEPOD™ LH, EC 130 B4
	X						D130-780-042	SPACEPOD™ RH, EC 130 B4
1		X					D130-780-043	DOOR ASSEMBLY, LH
	1		X				D130-780-044	DOOR ASSEMBLY, RH
1				X			D130-780-011	LH SLIDING DOOR HINGE KIT
1	1				X		D130-780-013	SWITCH RELOCATION KIT
				1		X	D130-780-015	CLOSEOUT KIT
2	2						D3815-041	WEB ASSEMBLY
3	3						D3815-5	PACKER
		1	1				D2589	KEYS, KEY CHAIN
1	1						D3837-1	DECAL
1	1						D3015-3	LOCK NUT
		1					D3186-3	SPACEPOD™ DOOR, LH
			1				D3186-4	SPACEPOD™ DOOR, RH
1							D3798-041	FLOOR
	1						D3798-042	FLOOR
1							D3188-5	SPACEPOD™ BODY
	1						D3188-6	SPACEPOD™ BODY
1	1						D3547-1	BRACKET
1	1						D3550-1	STRUT
		1	1				D3552-7	GAS SPRING
1	1						D3554-7	BALL STUD
4	4						AN3-3A	BOLT
4	4						AN3-6A	BOLT
2	2						AN3-10A	BOLT
1	1						AN5-5A	BOLT
38	38						AN525-10R7	SCREW
8	8						AN526C832R14	SCREW
6	6						MS24694S54	SCREW
7	7						MS24694S67	SCREW
1	1						MS24694S69	SCREW
		2	2				MS27039-0811	SCREW
8	8						A3235-020-935	WASHER
14	14						NAS1149D0363J	WASHER
16	16						NAS1149D0332J	WASHER
		4	4				NAS1149DN832J	WASHER
3	3						NAS1149D0563J	WASHER
		2	2				NAS1515H3	NYLON WASHER
		2	2				MS21042L08	NUT
22	22						MS21042L3	NUT (or MS21042-3)
1	1						MS21042L5	NUT
10	10						AKS7-1032-130	INSERT
28**	28**						AKS7-1032-130	INSERT
10	10						MS21059L3	NUTPLATE

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Revision: B

Date: 09.06.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

IIN-D130-780

Page 33 of 34

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
					2		D3819-1	MALE SPADE CONNECTOR
					2		D3597-1	FEMALE SPADE CONNECTOR
					1		D3598-2-096	EXPANDABLE SLEEVE
					24		D3599-1	TIE-WRAP
					24		D3600-1	TIE-WRAP MOUNT
					24 FT		M22759/41-22-9	WIRE
		1*	1*				D2464-1250	NEOPRENE SEAL
1**		1*					D3837-3	DECAL
	1**		1*				D3837-4	DECAL
		2*	2*				D2586	LATCH
		2*	2*				D2585	MOUNTING CHANNEL
		2*	2*				D2621	LATCH PLATE
		2*	2*				MS27039-1-15	SCREW
		2*	2*				NAS1149D0363J	WASHER
		2*	2*				MS21042L3	NUT (or MS21042-3)
		1*	1*				D2857-1	HINGE BRACKET
		1*	1*				D2857-2	HINGE BRACKET
		2*	2*				D2228	BACKING PLATE
		8*	8*				AN526C832R10	SCREW
		8*	8*				NAS1149DN832J	WASHER
		8*	8*				MS21042L08	NUT
		1*	1*				D3557-1	BRACKET
		2*	2*				D2228	BACKING PLATE
		1*	1*				D3554-7	BALL STUD
		1*	1*				NAS1149D0563J	WASHER
		1*	1*				D3015-3	LOCK NUT
		2*	2*				AN526C832R14	SCREW
		2*	2*				AN526C832R10	SCREW
		4*	4*				NAS1149DN832J	WASHER
		4*	4*				MS21042L08	NUT
2**	2**						D2237	STRIKER PLATE
4**	4**						MS20426AD4-5	RIVET
2**	2**						D3538-1	HINGE BRACKET
2**	2**						D2179	HINGE BRACKET PLATE
4**	4**						AN526C832R24	SCREW
4**	4**						NAS1149DN832J	WASHER
4**	4**						MS21042L08	NUT
				1			D3813-041	HINGE ASSEMBLY, UPPER DOOR
				1			D3813-043	HINGE ASSEMBLY, LOWER DOOR
				2***			D3518-3	ROD END

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Revision: B

Date: 09.06.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENC

DART AEROSPACE LTD.

REFERENCE ONLY

IIN-D130-780
Page 34 of 34

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
				2***			NAS509-6	NUT
				1			D3814-1	HINGE, UPPER AIRFRAME
				1			D3814-3	HINGE, LOWER AIRFRAME
				2			D3816-1	SPACER
				4			D3816-3	SPACER
				1			D3817-041	ANCHOR PLATE
				2			AN3-5A	BOLT
				3			AN3-7A	BOLT
				2			AN310-4	CASTLE NUT
				2			AN4-17	BOLT
				2			AN970-4	WASHER
				5			MS21042L3	NUT
				2			MS24665-212	COTTER PIN
				3			MS24694S46	SCREW
				8			NAS1149D0363J	WASHER
				2			NAS1149D0463J	WASHER
				1			D3552-7	GAS SPRING
				2			D3622-1	BALL STUD
				1			D3820-1	DOOR SUPPORT
				2			MS21042L5	NUT
				2			NAS1149D0563J	WASHER
				1			D3892-1	SEAL
						1	D3983-1	OUTER CLOSEOUT
						1	D3983-3	INNER CLOSEOUT
						1	D3983-5	HINGE CLOSEOUT
						1	D3983-047	CLOSEOUT ATTACHMENT
						1	D3983-9	SPACER
						2	AN525-10R6	SCREW
						1	AN525-10R24	SCREW
						1	NAS1149D0363J	WASHER
						1	MS21042L3	NUT

* Pre-installed on D3186-3/-4 Spacepod™ Door

** Pre-installed on D3188-5/-6 Spacepod™

*** Pre-installed on D3813-041/-043 Hinge Assemblies

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Revision: B
Date: 09.06.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries